

Work Order ID 72547

Thursday, July 28, 2011 3:08:07 PM



Page 1

Item ID: D3789-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 7/28/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 8/5/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3789

Rev A

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut extrusion to 1.250"

110

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

Machine as per Folio FA834

Dwg Rev:

Folio Rev:

Deburr

*Issue P.O to Meter 14641**R11-08-8**(10)*

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

15



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Receive & Inspect for transit damage
Memo
Ensure C/C attached

0.00

8/4/11 31 (10)

120



QC

Quality Control

QC2 Inspect parts - second check

0.00

Memo

0.00

8/10/11 31

(10)

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

10 8/11-8-31

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10X Ø M-11/08/31

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

*****Mask bearing bore prior to powder coat*****

START TIME: 7:40

OVENTEMPERATURE: 320 OF

FINISH TIME: 8-10

10X Ø M-11/09/01

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 Ø M-11/09/01

W/O: 72547

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3789-1

PAR #:

Fault Category: Finish

NCR: Yes No

DQA: CK

Date: 11/09/16

Resolution: Rework

Disposition: Rework

QA: N/C Closed: CK

Date: 11/09/16

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11-09-02	150	Print too thick - remove bearings - strip paint - re powder coat	W	- Remove Bearings - Strip all Qty x10 - re powder coat an accurate amount.	11/09/12 M-L	11/09/13	11-09-02	11/09/12
		Found when staking Bearings that the Powder Coat was extremely too thick.	11-09-02		11/09/13	11/09/13	11-09-02	11/09/12
		P.C. Lack of attention (Powder good, gun is working) emulsion applied too much.		→ Re QC3 (By QC Inspector)	11/09/13			11/09/13

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 8/5/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- press fit D2611 bearing after powder coat
2- stake D2611 bearing 4 places each side as per dwg D3789

EBA/09/13 (10)

180

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Dul09/14

(10)

190

0.00



Identify as per dwg & Stock Location: 37462

Packaging

Memo

0.00

Packaging

10X 11-09-14. h

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Cust Item ID:

Required Date: 8/5/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

u/9/16 JG
MF
11-09-15

Picklist Print

Thursday, July 28, 2011 3:08:04 PM

Page 1

Work Order ID: 72547

Parent Item: D3789-1

Parent Item Name: Clamp



Start Date: 7/28/2011

Required Date: 8/5/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev: A New Issue 08-12-10 DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2423		Manufactured	No			170	f	547.3900	0.07	0.736842			
-------	--	--------------	----	--	--	-----	---	----------	------	----------	--	--	--



Lug Extrusion

Location

Loc Qty

Loc Code

MAT006

547.39

43722

161.5

45800

1

63005

8.89

68331

376

D2611

Manufactured No

100

Each

40.0000

1

10



Bearing

Location

Loc Qty

Loc Code

ST018

40

68916

40

D3789-1P

10

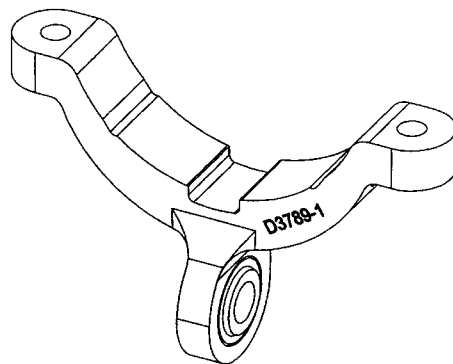
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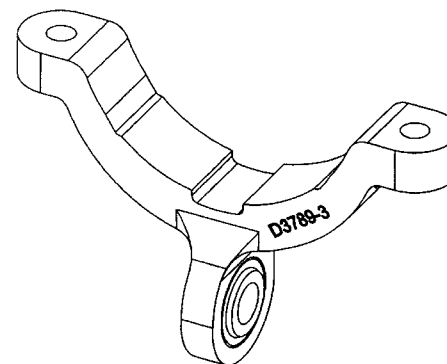
W 10/09/13

EP 09/13

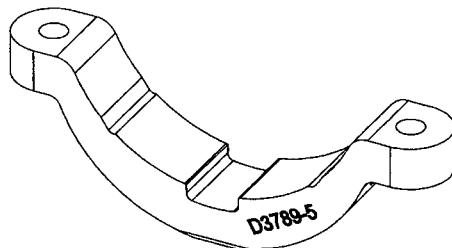
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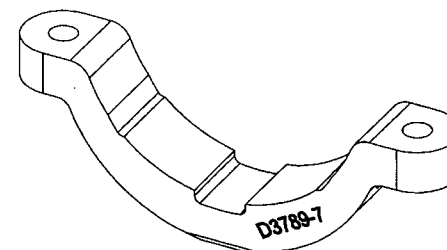
D3789-1 CLAMP



D3789-3 CLAMP



D3789-5 CLAMP



D3789-7 CLAMP

DEO ATTACHED

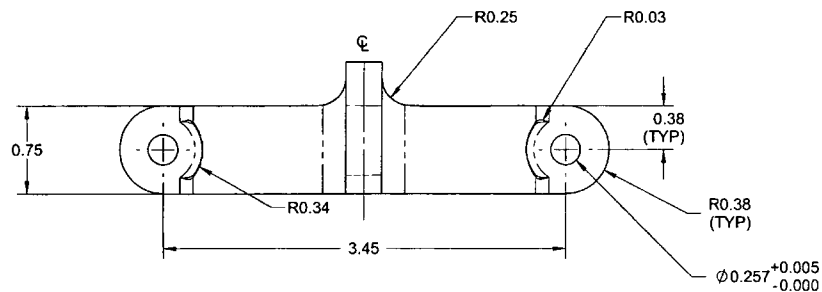
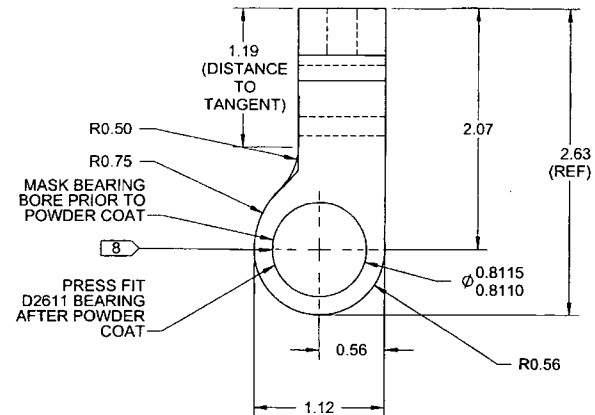
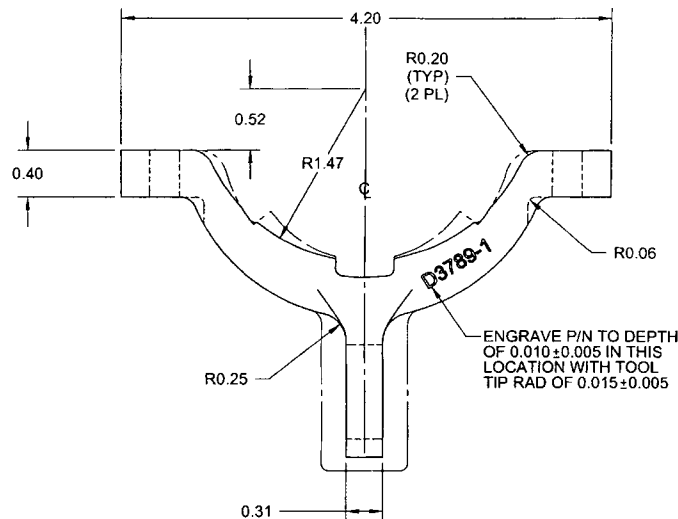
RELEASED
08/12/21

NOTES:

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 010 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N AS SHOWN
- 7) WEIGHT: D3789-1, 0.16 lbs
D3789-3, 0.16 lbs
D3789-5, 0.14 lbs
D3789-7, 0.14 lbs
- 8) STAKE D2611 BEARING 4 PLACES EACH SIDE AFTER POWDER COAT
- 9) PART IS SYMETRICAL ABOUT ϕ

a/o 72547




A NEW ISSUE		HS	08.05.21
REV.	DESCRIPTION	BY	DATE
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DATE	08.05.21	SHEET 1 OF 5	
		SCALE NTS	

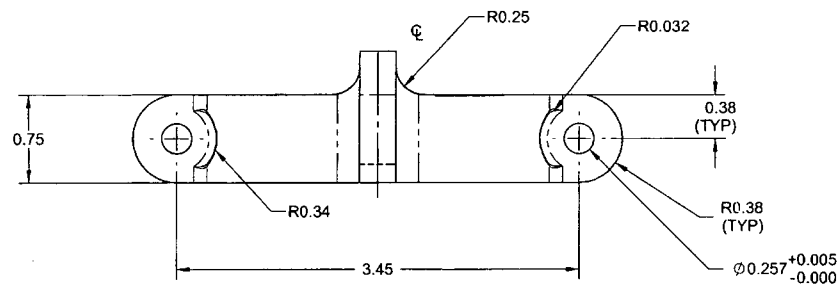
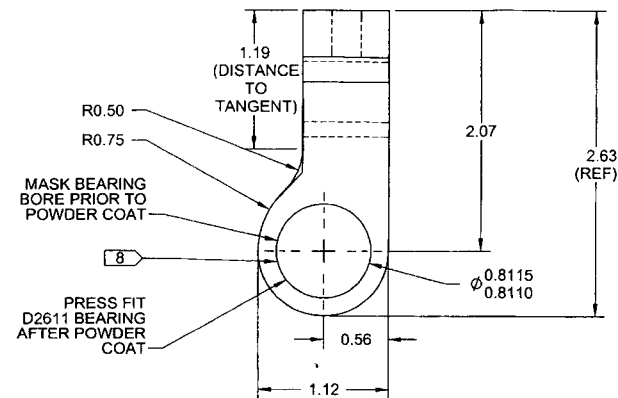
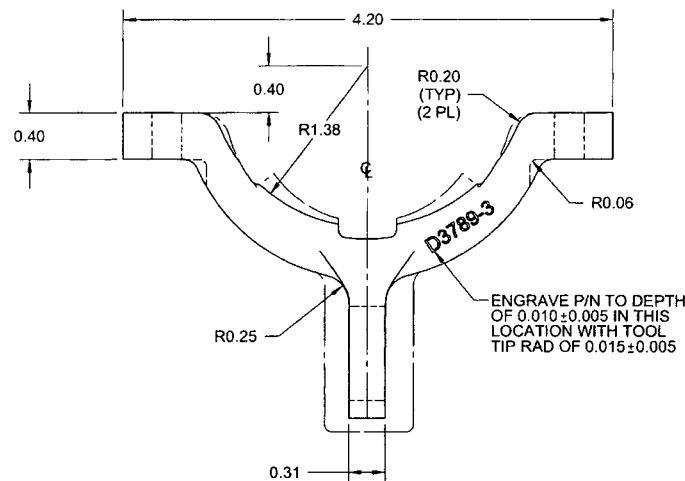


D3789-1 CLAMP

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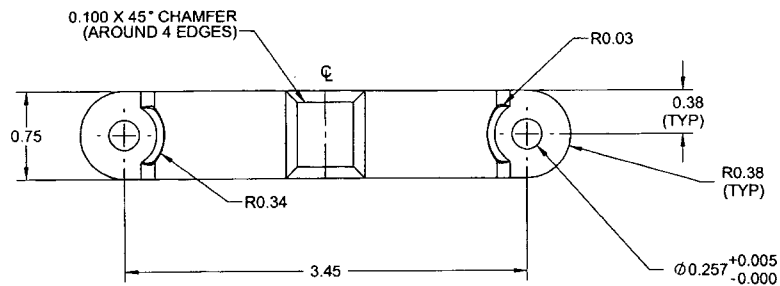
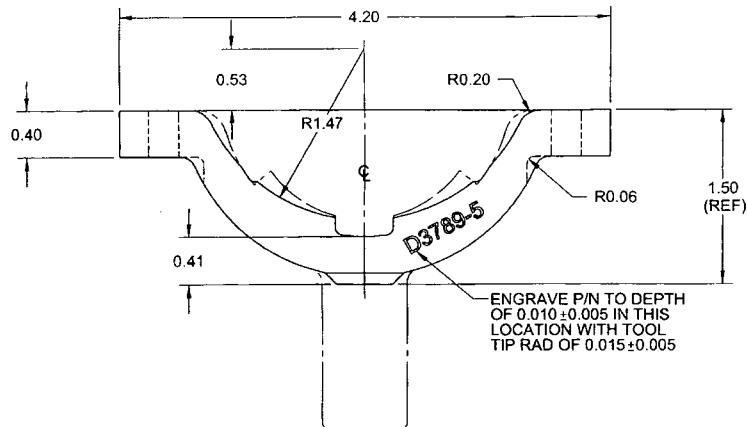


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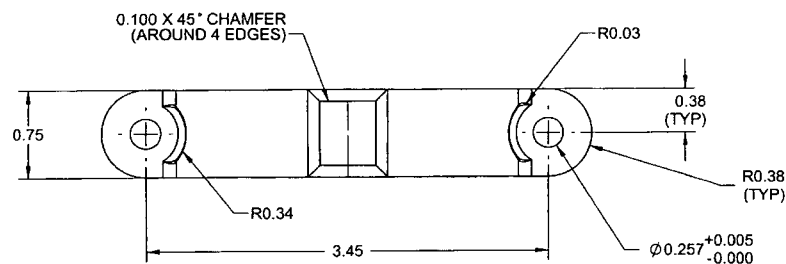
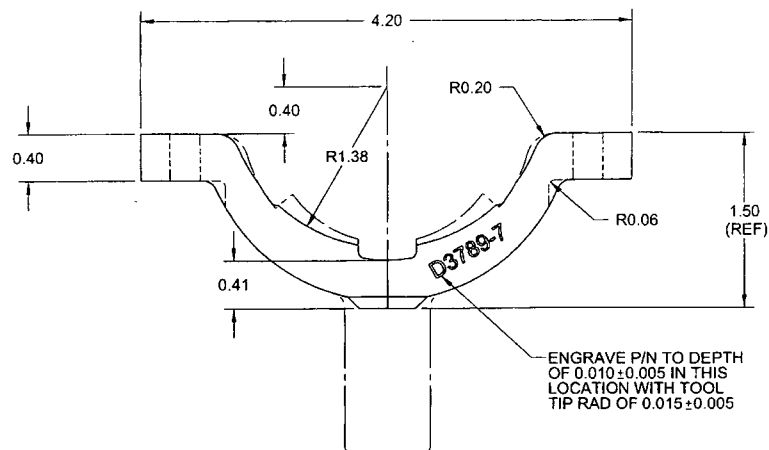


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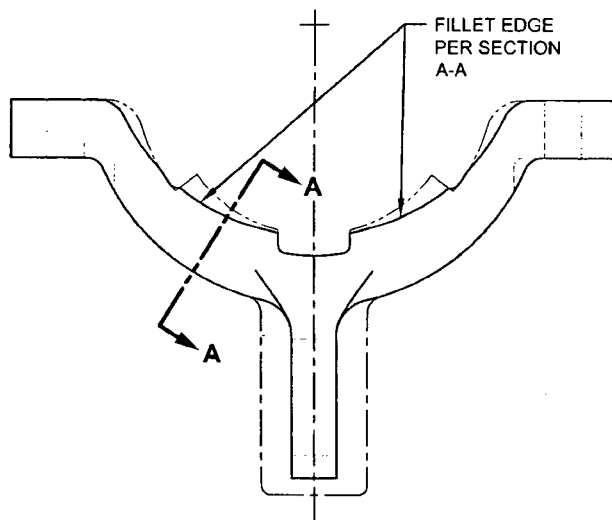
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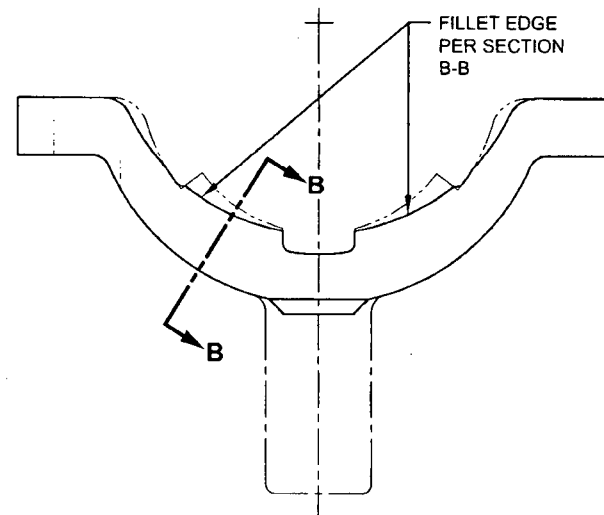
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DRAWN AJS	CHECKED b	MFG. APPR. [Signature]	APPROVED [Signature]		DE APPR. [Signature]		
DATE 09.04.20	DATE 09.04.23	DATE 09.04.23	DATE 09/04/23		DATE 09/04/23		

ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



D3789-1 CLAMP

D3789-3 CLAMP



D3789-5 CLAMP

D3789-7 CLAMP



R0.06 MIN - R0.10 MAX
2PL

SECTION A-A

SCALE 2X

SECTION B-B

SCALE 2X

SEE PAR 122 FOR FURTHER DETAILS

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Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 18138
Date: Aug 30, 2011
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 14641	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3789-1 Clamp Material supplied by DART: D2423 B68331	Each	10	10	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:


same


<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
10	<u>D3789-1</u>	Clamp	14641

MATERIAL: supplied by DART D3789 B68331

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz



Vankleek Hill, August 30, 2011